

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009118**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#13

This QA Inspector observed the following work in progress:

FCAW welding of weld joint 2G-223 located on PCMK SSD12-PP64 of 8AE welder is identified as 066683.

ZPMC QC is identified as Mr. Guo xing hui . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-TC-P4-F.

SMAW welding of repair weld joint 4G-032 located on PCMK SEG048* of 8CE welder is identified as 067656.

ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G (4F)-repair and WR-6830.

SMAW welding of repair weld joint 4G-031 located on PCMK SEG048* of 8CE welder is identified as 044772.

ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-4G (4F)-repair and WR-6829.

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FCAW welding of repair weld joint 2G-003 located on PCMK SSD10A-PP38 of 6AW welder is identified as 045276.ZPMC QC is identified as Mr. Zhang Qiang . The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-Repair.

During verification of Magnetic Particle Testing of the repaired location at OBG Segment 2AE. Caltrans Quality Assurance (QA) Inspector discovered one (1) Transverse indication 10mm in length in the weld metal location identified as PP15W-E7-04. These areas have been previously tested and accepted by ABF and ZPMC Quality Control MT Technicians. For more information please see the Incident report
04-0120F4_TL-15_B255_09-05-09__Seg_2AE_Side__Plate_MT_Transverse_Indication

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
